

Work Order ID 58474

May 7, 2010 10:24:18 AM



Page 1

Item ID: D130-701-011

Accept



Setup Start



Revision ID:

Item Name: Basket Conversion Installation

Stop



Start Date: 07/05/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: H

Date: 10-5-07 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D130-701

C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D130-701-011 CHG001

8/6/07/01

Handwritten signature and date: 10/07/01

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

Handwritten date: 10-6-30

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Handwritten date: 8/6/07/01

Handwritten circled number: 10

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Item ID: D130-701-011

Accept



Setup Start



Revision ID:

Item Name: Basket Conversion Installation

Stop



Start Date: 07/05/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D130-701-011 Location: _____ PPP Rev: <u>DRAFT</u>								
170 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Copy 7/01 (1)

10/07/01

W 10/07/01

Picklist Print

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Page 1

Work Order ID: 58474

Parent Item: D130-701-011

Parent Item Name: Basket Conversion Installation

Comments: IPP REV:A NEW ISSUE 10-04-19 JLM VERIFIED BY:DD

Start Date: 07/05/2010

Required Date: 14/05/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D4037-1		Manufactured	No			110	Each	0.0000	1			
---------	--	--------------	----	--	--	-----	------	--------	---	--	--	--



Aft Crossbeam

D4037-3		Manufactured	No			110	Each	0.0000	1			
---------	--	--------------	----	--	--	-----	------	--------	---	--	--	--



Fwd Crossbeam

D4038-041		Manufactured	No			110	Each	1.0000	1			
-----------	--	--------------	----	--	--	-----	------	--------	---	--	--	--



Angle Assembly, Fwd, LH

Location

Loc Qty

Loc Code

ST115

1

58048

D4038-042		Manufactured	No			110	Each	1.0000	1			
-----------	--	--------------	----	--	--	-----	------	--------	---	--	--	--



Angle Assembly, Fwd, RH

Location

Loc Qty

Loc Code

ST115

1

58049

D4038-043		Manufactured	No			110	Each	1.0000	1			
-----------	--	--------------	----	--	--	-----	------	--------	---	--	--	--



Angle Assembly, Aft, LH

Location

Loc Qty

Loc Code

ST115

1

58050

D4038-044		Manufactured	No			110	Each	0.0000	1			
-----------	--	--------------	----	--	--	-----	------	--------	---	--	--	--



Angle Assembly, Aft, RH

BS0464 10-7-1 SP

BS0465 10-7-1 SP

10-7-1 SP

10-7-1 SP

10-7-1 SP

B 59134 10-7-1-8

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Work Order ID: 58474

Parent Item: D130-701-011

Parent Item Name: Basket Conversion Installation











Comments: IPP REV:A NEW ISSUE 10-04-19 JLM VERIFIED BY:DD

Start Date: 07/05/2010

Required Date: 14/05/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D4039-041  Fwd Bracket Assembly		Manufactured	No			110	Each	0.0000	1			
										 B58469	10-7-15	
D4039-043  Aft Bracket Assembly		Manufactured	No			110	Each	0.0000	1			
										 B58469	10-7-15	
D4040-1  Radius Block		Manufactured	No			110	Each	8.0000	4			
										 10-7-15		
<div> <div>Location</div> <div>ST110</div> <div>57855</div> </div> <div> <div>Loc Qty</div> <div>8</div> <div>8</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>												
D4090-5  Placard		Manufactured	No			110	Each	4.0000	1			
										 10-7-15		
<div> <div>Location</div> <div>ST111</div> <div>57864</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>												
AN5-10A  Bolt		Purchased	No			110	Each	139.0000	16			
										 10-7-15		
<div> <div>Location</div> <div>ST337</div> <div>114199</div> <div>114227</div> </div> <div> <div>Loc Qty</div> <div>139</div> <div>100</div> <div>39</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>												

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Shop Packet Print

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Picklist Print

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Work Order ID: 58474

Parent Item: D130-701-011

Parent Item Name: Basket Conversion Installation

Comments: IPP REV:A NEW ISSUE 10-04-19 JLM VERIFIED BY:DD

Start Date: 07/05/2010

Required Date: 14/05/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

MS20002C5

Purchased

No

110

Each

28.0000

8



WASHER



10-7-1 SP

Location

Loc Qty

Loc Code

ST315

28

113595

28

MS20002C6

Purchased

No

110

Each

24.0000

12



WASHER



10-7-1 SP

Location

Loc Qty

Loc Code

ST315

24

113595

24

MS21042L5

Purchased

No

110

Each

625.0000

24



Nut



10-7-1 SP

Location

Loc Qty

Loc Code

ST300

625

113523

26

113537

3

114108

96

114437

100

114449

400

MS21042L6

Purchased

No

110

Each

369.0000

12



Nut



10-7-1 SP

Location

Loc Qty

Loc Code

ST300

369

111578

169

114495

200

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Work Order ID: 58474

Parent Item: D130-701-011

Parent Item Name: Basket Conversion Installation


Comments: IPP REV:A NEW ISSUE 10-04-19 JLM VERIFIED BY:DD

Start Date: 07/05/2010

Required Date: 14/05/2010

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS21250-05032  BOLT		Purchased	No			110	Each	8.0000	4	1		

Location Loc Qty Loc Code

ST305 8
113595 8


4

MS21250-05038  BOLT		Purchased	No			110	Each	8.0000	4			
---	--	-----------	----	--	--	-----	------	--------	---	--	--	--

Location Loc Qty Loc Code

ST305 8
114541 8


4

MS21250-06018  BOLT		Purchased	No			110	Each	24.0000	12			
---	--	-----------	----	--	--	-----	------	---------	----	--	--	--

Location Loc Qty Loc Code

ST305 24
113464 24

12

NAS1149D0563J  Washer		Purchased	No			110	Each	1,533.000	40			
---	--	-----------	----	--	--	-----	------	-----------	----	--	--	--

Location Loc Qty Loc Code

ST298 1533
113524 44
113706 1489

40

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Work Order ID: 58474



Parent Item: D130-701-011



Parent Item Name: Basket Conversion Installation

Start Date: 07/05/2010

Required Date: 14/05/2010

Comments: IPP REV:A NEW ISSUE 10-04-19 JLM VERIFIED BY:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
NAS1149D0663J		Purchased	No			110	Each	446.0000	12			



Washer



M114988 10-6-30 S

Location

Loc Qty

Loc Code

ST298

446

113524

246

114348

200

REFERENCE ONLY

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D130-701-041 (LH installation)	120 lb 54 kg	- 47.4 in - 1.20 m	- 5688 in-lb - 64.8 m-k-g	133.9 in 3.40 m	16068 in-lb 183.6 m-k-g
D130-701-041 (RH installation)	120 lb 54 kg	+ 47.4 in + 1.20 m	+ 5688 in-lb + 64.8 m-k-g	133.9 in 3.40 m	16068 in-lb 183.6 m-k-g
2 x D130-701-041 (LH and RH installation)	224 lb 102 kg	0.0 in 0.00 m	0 in-lb 0.0 m-k-g	133.9 in 3.40 m	29994 m-k-g 346.8 m-k-g
D130-701-043 (LH installation)	130 lb 59 kg	- 47.4 in - 1.20 m	- 6162 in-lb - 70.8 m-k-g	133.9 in 3.40 m	17407 in-lb 200.6 m-k-g
D130-701-043 (RH installation)	130 lb 59 kg	+ 47.4 in + 1.20 m	+ 6162 in-lb + 70.8 m-k-g	133.9 in 3.40 m	17407 in-lb 200.6 m-k-g
2 x D130-701-043 (LH and RH installation)	235 lb 106.8 kg	0.0 in 0.00 m	0.0 in-lb 0.00 m-k-g	133.9 in 3.40 m	31467 in-lb 363.1 m-k-g
D130-701-013 (Fixed provisions)	25 lb 11.4 kg	0.0 in 0.00 m	0.0 in-lb 0.00 m-k-g	133.9 in 3.40 m	3348 in-lb 38.8 m-k-g

5. PARTS LIST

Qty -041	Qty -043	Qty -011	Qty -013	Part Number	Description
X				D130-701-041	HELI-UTILITY-BASKET
	X			D130-701-043	HELI-UTILITY BASKET
		X		D130-701-011	CONVERSION KIT
			X	D130-701-013	FIXED PROVISIONS KIT
2	2			*D2022-101	SPACER
1	1			*D2258-220	LABEL
1	1			*D2332-041	PROP ASSEMBLY
1	1			*D2512	BASKET LID ASSEMBLY
1	1			*D2530	HANDLE ASSEMBLY
2	2			*D2535	SPRING
2	2			*D2537	BUSHING
2	2			*D2931	BUMPER
1	1			*D3172-041	BASKET BASE ASSEMBLY
2				D3173-041	BEAM ASSEMBLY
1				D3177-041	BRACKET ASSEMBLY
1				D3177-043	BRACKET ASSEMBLY
1	1			D3180-041	STRUT ASSEMBLY
1	1			D3181-1	BUSHING
	1	1	1	D4037-1	AFT CHANNEL
	1	1	1	D4037-3	FWD CHANNEL
	1	1	1	D4038-041	ANGLE ASSEMBLY, FWD, LH
	1	1	1	D4038-042	ANGLE ASSEMBLY, FWD, RH
	1	1	1	D4038-043	ANGLE ASSEMBLY, AFT, LH
	1	1	1	D4038-044	ANGLE ASSEMBLY, AFT, RH
	1	1		D4039-041	FWD BRACKET ASSEMBLY
	1	1		D4039-043	AFT BRACKET ASSEMBLY
	4	4	4	D4040-1	RADIUS BLOCK
	1	1		*D4090-1	PLACARD (ON BASKET LID)
	1	1		*D4090-3	PLACARD (ON BASKET LID)

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Revision: C

Date: 10.01.01

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -041	Qty -043	Qty -011	Qty -013	Part Number	Description
	1	1	1	D4090-5	PLACARD
2	2			*AN3-16A	BOLT
2	2			AN4-12A	BOLT
1	1			*AN4-22A	BOLT
1	1			*AN4-24A	BOLT
3 (2)	3 (2)			+AN4-7A	BOLT
4	16	16	16	AN5-10A	BOLT
4	4			*AN5-17A	BOLT
2				AN5-23A	BOLT
4	4			*AN970-4	WASHER
	8	8	8	MS20002C5	WASHER
	12	12		MS20002C6	WASHER
2	2			*MS20600AD4W3	RIVET
2	2			*MS21042L3	NUT (OR MS21042-3)
7 (4)	7 (4)			+MS21042L4	NUT (OR MS21042-4)
10 (4)	28 (4)	24	24	+MS21042L5	NUT (OR MS21042-5)
	12	12		MS21042L6	NUT (OR MS21042-6)
	4	4	4	MS21250-05032	BOLT
	4	4	4	MS21250-05038	BOLT
	12	12		MS21250-06018	BOLT
2	2			*NAS1149DN832J	WASHER (AN960JD8)
2	2			*NAS1149D0416J	WASHER (AN960JD416L)
7 (2)	7 (2)			+NAS1149D0463J	WASHER (AN960JD416)
16 (4)	44 (4)	40	40	+NAS1149D0563J	WASHER (AN960JD516)
	12	12		NAS1149D0663J	WASHER (AN960JD616)

* Pre-assembled prior to shipping

+ Quantity in () preassembled prior to shipping

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Revision: C

Date: 10.01.01

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9370	REV. A SHEET 1 OF 1
DATE 07.02.27		TITLE PLACARD REPLACEMENT SCALE NTS	
REV A	DATE 07.02.27	DESCRIPTION NEW ISSUE	

DART SERVICE INSTRUCTION

When the D350-607-XXX and D130-701-XXX Heli-Utility Baskets are installed on a Brazilian registered aircraft, replace a portion of the D2258-XXX Placard located on the D2506 Label Plate on the Basket Lid with D3605-1 Placard as follows:

1. Remove letters as indicated in Figure 1 below by lifting the edge and carefully peeling each letters at an angle of 90 to 180 degrees. Speed and angle of removal may affect amount of residue and the amount of paint removed.
2. Remove adhesive residue using 4105S Wash 'n' Wipe Degreaser or MEK (or equivalent). Scrape softened adhesive off surface using a plastic squeegee. Repeat if required.
3. Saturate a clean cotton cloth with 4105S Wash 'n' Wipe Degreaser or MEK (or equivalent) and wipe the surface to clean the entire area.
4. If necessary, touch up paint in accordance with relevant ICA (ICA-D350-607 or ICA-D130-701).
5. Install D3605-1 Label per Figure 2 using a 3M PA-1 Plastic Applicator (or equivalent) to work out blisters as required.

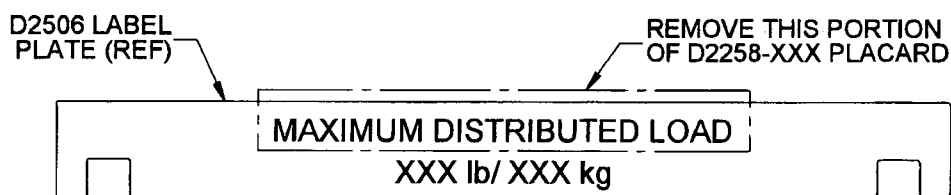


FIGURE 1: PARTIAL REMOVAL OF D2258-XXX PLACARD

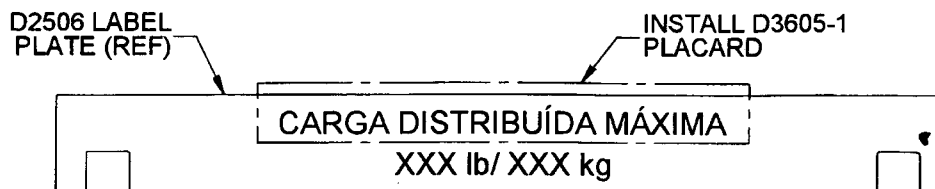


FIGURE 2: INSTALLATION OF D3605-1 PLACARD

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